



Item ID: Revision ID:	D3929-041				Accept	*N900	1040	100)* s	etup Sta	rt *N	S1*
	Gusset Assembly	-								Sto	^p *N	S2*
Start Date: Required Date:		tart Qty: 2.00 eq'd Qty: 2:00		*2* *2*		Cust Item Customer						
Reference:	•		· <u>s</u>									
Approvals:	Process Plan:	CS	Date:	12/10/1	Tooling:	· I	Date:		F	tun Sta Sto	171	R1*
	QC:		Date:		SPC (Y/N):	I	Date:			310	* *N	R2*
Sequence IE. Work Center L		paration secuption	•	→	A Jp! Lan Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revisio	n Nbr										
D3929	Rev A											
100					0.00							
100 Waterjet		Memo			0.00				0		B(Z	L-10 16
FLOW CNC Waterjo	et	1-Cut as Dwg Rev Prog Rev	per Dwg D392 v:	9								
		2-Debur	if necessary									
110	QO	C2- Inspect parts of	ff machine FAI/	FAIB	0.00				- \			
110 QC		Memo			0.00						<u> Bl</u>	2-10-16

												DQA:	Date	•
NCR: Y	es	/ No					WORK ORDER NON-C	:01	VFOR	MANCE / UPDATE				
							· · · · · · · · · · · · · · · · · · ·	,			C	(A Closed:	Date	
Nork Orde	r:						DISPOSITION			AGAINST	DEP	ARTMENT	PROCESS	
Part No	o						Rework Scrap Use-as-is			Skid-tube Crosstube Machining Small Fab noforming Finishing			Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	o						Work Order Update			Large Fab Composite			Supplier	
Root					Des	crip	otion of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		C	r Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
oc/Data														
quip/Tooling														
perator														
laterial										•				
etup	\neg	1								·				
ther														
rocess	╗													
upplier	╗										ŀ			
raining	ヿ									·				
napproved	┪													
					·····		F.A	AUL	T CATE	GORY	····	1.1		
Landin	g G	ear					General			······································	: _	- 1		7
Γ	\Box	Bending			ſ		Bend		Grain		\Box	Ovalized	Γ	Pressure/Forced
ſ	\neg	Centre No	t Concer	ntric to C	o/s		BOM/Route		Hardwa	ire	П	Over/Under	tolerance	Temperature/Cure
Γ	٦	Cracks			Ī		Broken/Damaged		Inspect	ion Incomplete	\square F	art Incorre	t -	Weld
Γ	\neg	Crushed/C	rimped.				Burrs	Г	Instruct	tions Incomplete/Unclear	F	art Lost/Mi	ssing	Wrong Stock Pulled
T	→	Cuffs	-				Contamination		Mainte	·	H	Part Moved		
	-	Heat Treat	t				Countersink		Mislabe	eled	l l	ositioned V	Vrong	
Ī	٦,	Inspection	Strip in	Tube	1		Cut Too Short		Misread	d	f	ower Loss/	Surge	Other
. F	_	Ripples in	-				Drill Holes		Offset		_		_	
-	_	Torque Wa		xtrusior	,		Drawing		4	Calibration	_			
		Turning Se					Finish	Г	Out of	Sequence	-			· · · · · · · · · · · · · · · · · · ·

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

0.00

Q

QC9- Inspect visual per QSI004- Fusion Welds

Memo

150

QC

Quality Control

NCR:	Yes	1	No
IVCK:	162	/	IVO

								<u>.</u>		DQA:	Date	:	
NCR: Y	es / N	o			WORK ORDER NON-O	CON	FOR	MANCE / UPDATE			•		
					<u>, </u>					QA Closed:	Date	:	
Work Orde	er:				DISPOSITION			AGAINST	DEI	PARTMENT	/PROCESS		
Part N					Rework Scrap Use-as-is		! Thern	Skid-tube Crosstube Machining Small Fab noforming Finishing			Water Jet d. Eng. Coor. re/Packaging		eering Quality Other
NCR N					Work Order Update]	(%	Large Fab Composite			Supplier		
Root				Descri	ption of work order update	lr	nitial	Action		Sign &			
Cause	Dat	Step	Qty		or Non-conformance	Chi	ef Eng	Description		Date	Verification	QC	Inspector
Doc/Data											-	1	
Equip/Tooling												}	
Operator													
Material		ŀ											·
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Other													
Process						1		·					
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Training		*					,		1				
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	·				F.	AUL1	CATE	GORY		·			
Landir	ng Gear	•	منتب		General	_						·. 	
	Bendi	g			Bend		Grain			Ovalized		_	e/Forced
	_	Not Conce	ntric to	o/s	BOM/Route		Hardwa	ire	_	Over/Under	-	⊣ `	ature/Cure
	Cracks				Broken/Damaged		Inspecti	ion Incomplete	L	Part Incorre	ct	Weld	
	Crushe	d/Crimped			Burrs		Instruct	tions Incomplete/Unclear	_	Part Lost/M	issing	Wrong:	Stock Pulled
	Cuffs				Contamination	Ш	Mainte	enance	L	Part Moved			
	Heat T			<u></u>	Countersink	Ш	Mislabe	eled		Positioned V		_	
]		tion Strip ir	1 Tube		Cut Too Short	Ш	Misread	d		Power Loss/	Surge	Other	
	Ripple	s in Bend			Drill Holes	Ш	Offset						
	Torqu	e Waves in	Extrusio	n	Drawing	Ш	Out of (Calibration					
	Turnir	g Sequence	•		Finish		Out of S	Sequence					

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Work Orde October 16, 201				*917	24*					Page 3
Item ID: Revision ID: Item Name:	D3929-041 Gusset Assem	bly		Accept	*N90004	೧1 00*	Setup	Start Stop	*NS	
Start Date: Required Date: Reference:	10/16/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:				INIT	
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):	Date:Date:		Run	Start Stop	*NR	
Sequence ID/ Work Center II 160 *160* QC Quality Control		Operation Description QC5- Inspect part completed Memo	teness to step on W/O	Set Up/ Run Hour 0.00 OSS	Tool ID - Too	Plan Acce Code Qty	pt Re Qt		Reject I Number -S	nsp.
170 *170* Packaging Packaging		Identify as per dwg & Stoo	ck Location: (i) 🖒 🖰 C	0.00	13.1.4	2	·	·		
*180 *180*		QC21- Final Inspection - \(\text{Memo} \)	Work Order Release	0.00				13/	1/10	49

Quality Control

NCR:	Yės	/ No				WORK ORDER NON-	COI	NFORM	ANCE / UPI	DATE	04.65	D. 4.	
								<u> </u>			QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK OIU	٠					Rework	٦.		Skid-tube	Crosstube		Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1		noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	۷o.					Work Order Update			Large Fab	Composite]	Supplier	
	_		1	r			1		·		C: 0		1
Root						ption of work order update		Initial		tion	Sign &	Varification	OC Inspector
Cause	\dashv	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data	$\vdash \vdash$												
Equip/Tooling	\vdash						ļ						
Operator	\vdash												
Material	Н												
Setup Other	Н												
Process	H												
Supplier	H												
Training							1	. V				-	
Unapproved								* G					
							AUI	LT CATE	GORY				
Landi	ng G	Gear				General	_	7		_	-1	_	- 1
		Bending				Bend	<u> </u>	Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced
		Centre No	ot Conce	ntric to (o/s	BOM/Route	<u> </u>	Hardwa		<u> </u> _	Over/Under	⊢	Temperature/Cure
	-	Cracks			<u> </u>	Broken/Damaged	-	-1	ion Incomplete		Part Incorre	 	Weld
	_	Crushed/	Crimped		<u> </u>	Burrs	_	-1	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	<u> </u>	Cuffs				Contamination	\vdash	Mainte		<u> </u>	Part Moved	.,	
1	<u> </u>	Heat Trea				Countersink	\vdash	Mislabe		_	Positioned \		704
		Inspectio	•	Tube	<u> </u>	Cut Too Short	\vdash	Misread	d	L	Power Loss,	Surge	Other
	\vdash	Ripples ir			<u> </u>	Drill Holes	\vdash	Offset	C-111				
1	ı	Torque V	vaves in I	extrusio	า	Drawing	- 1	Out of (Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

October 16, 2012 1:41:03 PM

Work Order ID:

91724

Parent Item:

D3929-041

Parent Item Name: A Gusset Assembly

Start Date: 10/16/12

Required Date: 10/19/12

Page 1

Start Qty: 2.00

Required Qty: 2.00

C			4.
Cor	mm	ıen	ts

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
W304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	179.3500	0.45	0.9473684	B	12-10-	طا
				Location	•	Loc Qty	<u>Lo</u>	c Code					
				MAT020		179.35					<u> </u>		
				1225	21	179.35			122	521	(2)		
D3907-1		Manufactured	No			130	Each	37.0000	2	4			
Bushing			•			•							
				Location		Loc Qty	<u>Lo</u>	c Code					
				WA		37					- /-	/	
18				8889	1	1			<u>(×</u>	(4) F	3/01	1/03	M
				(8968	8 X 4	36				<u> </u>	,	, -	. ,

												DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UP	DATE		0.1.61	.	
								T				QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST [ÞΕΙ	PARTMENT	PROCESS	
Part I NCR I	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
	•						_							. L
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Desc	ription		Date	Verification	QC Inspector
Doc/Data	Ш				•									
Equip/Tooling							ļ							
Operator			1											
Material														7.
Setup		!												Í
Other												·		
Process								٠						
Supplier			İ											
Training	П								: II					
Unapproved	П													
						F	AUI	LT CATE	GORY					
Landi	ing G	ear				General		-		_		_		-
	Ш	Bending				Bend		Grain	•			Ovalized		Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	L	Hardwa	re			Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved	-	
		Heat Trea	it			Countersink		Mislabe	led			Positioned V	Vrong	_
	П	Inspectio	n Strip in	Tube		Cut Too Short	Г	Misread	I	:		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

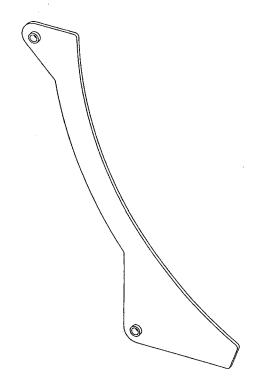
Drill Holes

Drawing

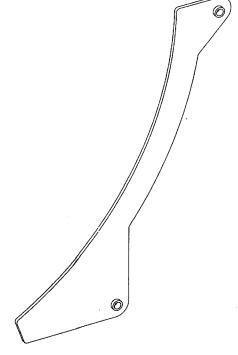
Finish

QTY -041 QTY -042 ITEM P/N DESCRIPTION D3929-041 GUSSET ASSEMBLY
GUSSET ASSEMBLY X D3929-042 2 D3907-1 1 D3929-1 BUSHING SUPPORT GUSSET 11

D



D3929-041 GUSSET ASSEMBLY

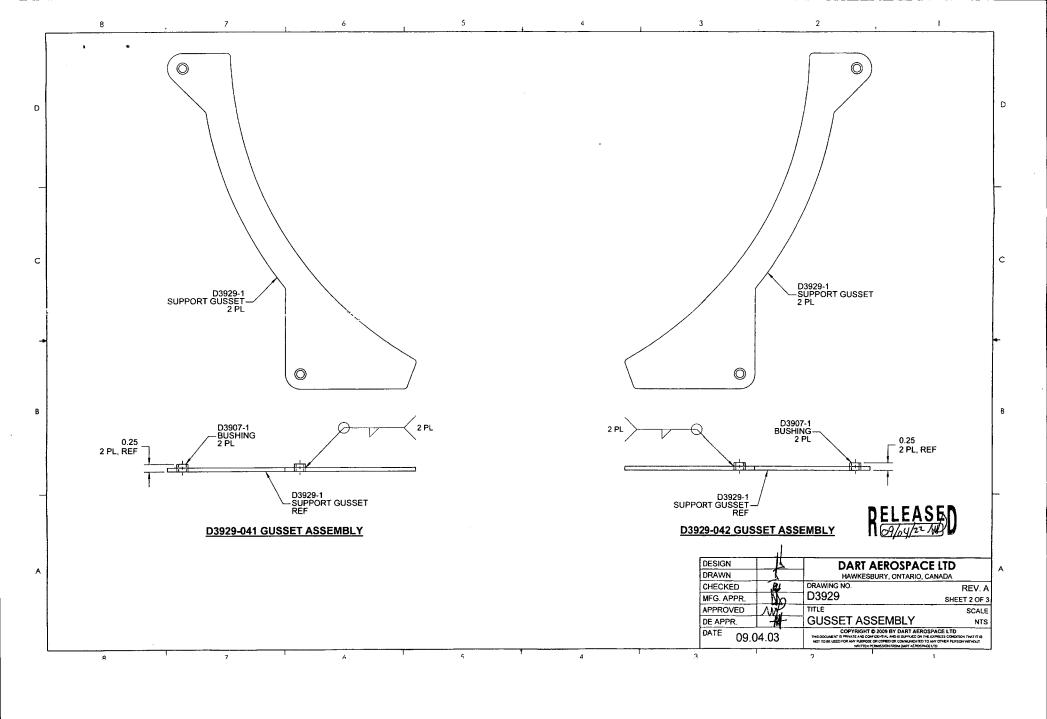


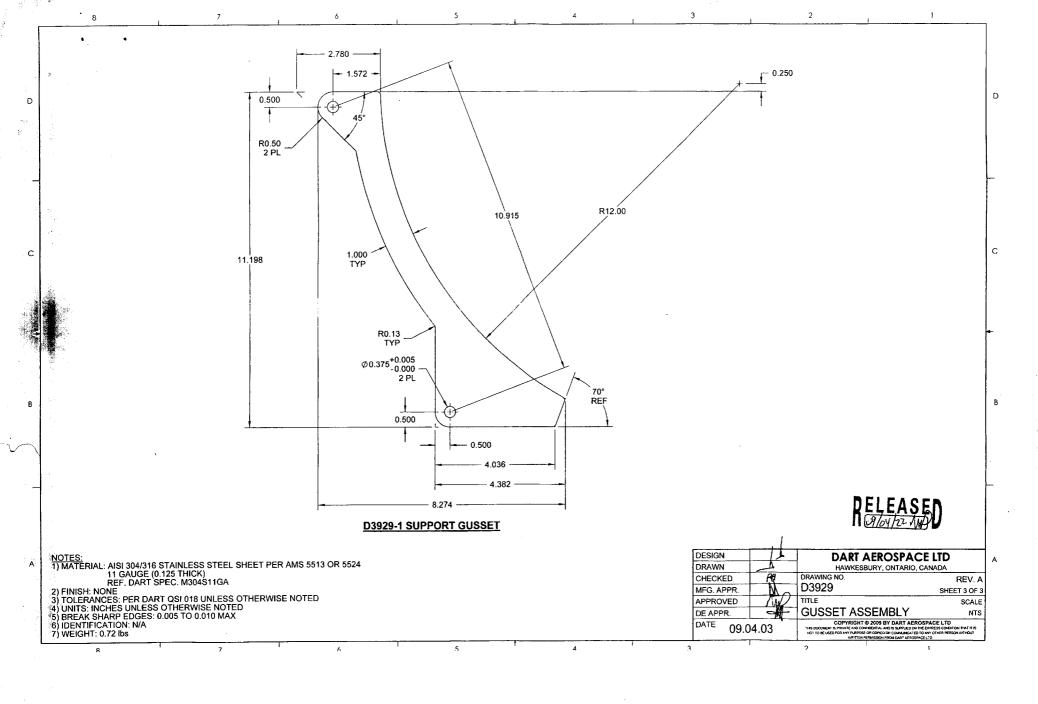
D3929-042 GUSSET ASSEMBLY

Calalio/16 100: 91724

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004

Α	NEW ISS	SUE		мв	09.04.03		
REV.			DESCRIPTION	BY	DATE		
DESIG	N .	14	DART AEROSPA	CE L	ĪD		
DRAW	V		HAWKESBURY, ONTARIO	, CANA	DA		
CHECH	ED	PH	DRAWING NO.		REV. A		
MFG. A	PPR.	M	D3929		SHEET 1 OF 3		
APPRO	VED	MI	TITLE		SCALE		
DE API	PR.	#	GUSSET ASSEMBLY		NTS		
DATE	09.0	4.03	COPYRIGHT @ 2009 BY DART AEROSPACE LTD THIS OCCUPENT IS PRIVATE AND CONTIDENTIAL AND IS SUPPLIED ON THE PRIVATE AND CONTIDENTIAL AND IS SUPPLIED ON THE PRIVATE AND CONTIDENTIAL AND IS SUPPLIED TO ANY OTHER PRISON WITHOUT AND ANY ARROPMENT TO THE PRISON WITHOUT ARROWS AND ANY ARROWS AND THE PRISON WITHOUT ARROWS AND ANY ARROWS AND THE PRISON WITHOUT ARROWS AND ANY				





DART AEROSPACE LTD	Work Order:	9/724
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.006/-0.001	.317	2		V 1867	
0.500	+/-0.010	,508	7		V	
0.500	+/-0.010	.568	h		V	- 10 -
4.036	+/-0.010	4,030	7		V	
4.382	+/-0.010	4,03(V	
8.274	+/-0.010	8.274	0		V	
10.915	+/-0.010	16,917	8		PRONZOZ	
1.000	+/-0.010	1.010	2		V	
11.198	+/-0.010	11.198	1		P	
0.500	+/-0.010	-501	1		V	
1.572	+/-0.010	1.572	1		V	
0.125	+/-0.010	151			V	

Measured by: B	Audited by: $5n\beta$	Prototype Approval:	N/A
Date: (2-10-1)	Date: 10 10 17	Date:	N/A

	Rev	Date	Change		Revised by	/ Approved
	Α	09.05.27	New Issue	P/O D3929-041/-042	KJ KJ	
-						

